Al TAKAMUL COMPANY FOR ENGINEERING TESTS AND PROFESSIONAL SAFETY LIMITED
Basra, North Rumaila, Quality Control Yard - Iraq
Tel: +9647810009138 / +9647834964657
Email: OP@qualitycontrol-iraq.com / hany.akafi@qualitycontrol-iraq.com

# AFTER REPAIR INSPECTION CERTIFICATE OF X-OVER#BFS JC-23-114

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| **Client Name:** | HILONG OIL SERVICE&ENGINEERING CO,Ltd IRAQ BRANCH. | Report No.: | QC-2024-09-HL-22-003 |
| Acceptance Criteria. | ☑API SPEC 7-2 | Date of Inspection: | 12.SEP.2024 |
| **Work Location:** | ABERDEEN WORKSHOP BASRA IRAQ | Rig No.: | HL-22 |
| TEST EQUIPMENT & CONSUMABLE DETAILS | | | |
| WHITE CONTRAST WCP-2 | Batch #: 220602 Manufacture: Magnaflux Exp Date: JUN,2025 | TECHNICAL DETAILS | Wet Visible Continuous |
| BLACK INK 7HF | Batch#.220605 Manufacture: Magnaflux Exp Date: JULY.2025 | COIL(1200 AMP-TURNS/IN | 22713 Cal.25.JUL.2024 Cal Due24.FEB.2025 |
| FLUORESCENT 14HF | Batch #: 220306 Manufacture: Magnaflux Exp Date: March.2025 | A.C HAND YOKE | PY-10 Cal.25.JUL.2024 Cal Due24.FEB.2025 |
| INTENSITY METER | SR#1608000134 CAL.Date Cal. 25.JUL.2024 Cal Due 24.FEB.2025 | UV BLACK LIGHT | SR#1895313 Cal.25.JUL.2024 Cal Due24.FEB.2025 |
| LEAD GAGE | SR#AH07KF0026 GAEMAKER LG- Cal. 25.JUL.2024 Cal Due 24.FEB.2025 | THREAD PROFILE GAGE | SR#21336 Cal. Cal.25.JUL.2024 Cal Due24.FEB.2025 SR#21335 Cal. Cal.25.JUL.2024 Cal Due24.FEB.2025 |
| Magnetic Partical Concentration 7 HF | 1.2 TO 2.4 ML/100 ML | WMPT Light Intensity | 3450 Lux |
| Magnetic particle concentration flourcent 14 HF | 0.1 TO 0.4 ML/100 ML | UV LIGHT INTENSITY: | 2850 µw/cm² |
| Magnetism Direction (Longitudinal) | | | |
| METHODOLOGY: | • Through Visual inspection • Dimensional | •MPI inspection with Ultraviolet light *Lead Gaiging, & Thread Profile Gauging. | |

| Serial No. | Description | Connection | | Result Inspection | | | Dimensional - Inspection | | | | | | | | | | | | | | |
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| | | | | | | | Pin | | | | | | Box | | | | | | Body | | |
| | | Pin | Box | Pin | Box | Body | OD(In) | ID(In) | SRG □(In) | SRG W □(In) | Pin □(In) | Bevel □(In) | OD(In) | CB ϕ(In) | CB δ(In) | BB ϖ(In) | BB λ(In) | Bevel ϕ(In) | Box ong λ (in) | Box Tongspac e (In)□ | Overall □(IN) |
| BFS JC-23-114 | X-OVER | - | 5 ½" FH | - | NO B.B | - | - | - | - | - | - | - | 7 30/32" | 5 29/32" | 5/8" | - | - | 7 12/32" | - | - | - |
| **Conclusion :** | *01 X-OVER above was found "Acceptable" From BOX Connnection After Repair At the time of Inspection.NO BORE BACK NOTE: Pin Stress Relief Groove: Unless waived by the customer, all APIconnection NC38 and larger that make up to BHA components shall be equipped with pin stress relief grooves or they shall be rejected they diemeter and width of the API pin strss relief grooves shall be measured and shall meet the erquirements of table 3.9 Box Bore Back: unless waived by the customer all API connection NC 38 and larger thet make up to BHA components shall be equipped with bore back boxes or they shall be rejected dimeter and length of the bore back cylinder shall be measured and shall meet the requirements of table 3.9 | | | | | | | | | | | | | | | | | | | | | |

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| **OD** | *Outside Diameter* | **ID** | *Inside Diameter* | **SRG** | *Stress Relief Groove* | **CB** | *Counter Bore* | BB | *Bore Back* | **FB** | *Float Bore* |
| □ | *Diameter* | □ | *Length* | □ | *Width* | □ | *Depth* | ***NP.*** | *Not Present* | ***NA.*** | *Not Applicable* |
| **EGR** | *Elevator Groove Recess* | **SGR** | *Slip Groove Recess* | **CR** | *Crack* | **B** | *Bent* | **PC** | *Premium Class* | **RF** | *Reface* |
| **GT** | *Galled Thread* | **TP** | *Thread Pitting* | **SP** | *Seal Pitting* | **TD** | *Thread* | **SD** | *Seal Damage* | **M** | *Mashed* |
| **1** | *100 % Coating* | **2** | *99-71 % Coating* | **3** | *70-40 % Coating* | **4** | *Up to 40 %* | **5** | *Nil* | **WT** | *Wall Thickness* |
| ***Colors Code:*** | | ***White*** | **No Defects** | *Red* | **Crack or Extreme** | **Blue** | **Damage** | **Green** | **Seal Damage** | **Yellow** | **ACFM** |

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| **Inspector Name:** | RAO SOHAIL | **Review By** | | | | | | |
| **Qualification:** | (ASNT Level II) | **Senior Inspector:** | M.SARWAR | **Supervisor:** | AHMED MOHAMMED | **Customer Name:** | | |
| **Signature:** | | | | | | **Customer Signature:** | | |

Al Takamul Company For Engineering Services — QUALITY CONTROL

Original - Client Files  Copy - Area Office  QC/FN/DJ-PB/029 Rev.00 dated 07.Nov2021